

Work Order ID 136898

Wednesday, September 16, 2015 3:35:21 PM

136898

Page 1

Ship Out 7/15

Item ID: D3230-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Wedge Assembly
 Start Date: 9/17/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/02/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *SAH* 20150916 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3230	D								

110 Large Fab 0.00

110

Large Fab Memo 0.00

Large Fab 1-Cut 3/4 x 3/4 square tubing as per Dwg D3230

2- Drill and c/sink holes

3- Cut mesh as per dwg

4 -Deburr & Remove all Markings From Material

5-Weld bushings and fabricate basket wedge assembly as per D3230

6- USE DT10137 TO LOCATE BACK HINGE AS PER DWG.

LOOK AT DWG FRONT MESH MUST BE WELDED INSIDE

A/R SS ROD Batch: *M13147*

(PTO)

DAS
43
9-89 SEP 24 2015

P.T.O.

DQA:

Date: 16/01/15



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ~~RA~~

Date: 15/12/08

Work Order update only ☐

Work Order: <u>136898</u> Part No. <u>D3230-041</u> NCR No. <u>15-3485</u>		DISPOSITION Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Date: <u>15-10-06</u>		Step #: <u>2</u> <u>100</u>		QTY Effective: <u>2</u>		MRB (QSI042) Approval DAS 22 15.10.05 9-89			
Description Work Order Deviation				Disposition					
D2232-3 WELDED AT WRONG PLACE. R.C.: WRONG JIG USED WAS MADE FOR WEDGE. NEW JIG WAS REDESIGNED AFTER TO FIT DIMENSIONS ACC TO DWG <u>SCRAP WRONG JIG.</u>				REMOVE D2232-3 WITHOUT DAMAGE TO STAIN TUBULAR STRUCTURE. USE CORRECT JIG: <u>DT 10137</u> TO WELD AT CORRECT PLACE. D2232-3 <u>D2232-3: B115847</u> <u>ROD: 4131417</u>				Completed By DAS 43 OCT 05 2015 9-89 Lead hand / Supervisor Approval Verification DAS 24 9-89 AUG 06 2015 QC / QA Coordinator Approval DAS 9-89 OCT 06 2015	
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Crushing ☐ Countersink ☐ Off-set ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ OTHER: ☐						☒ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

AUG 06 2015

DAS
24
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

AUG 06 2015

DAS
24
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

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180	Identify as per dwg & Stock Location: _____ Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

OCT 07 2015

DEF
63
9-89

MCS

OCT 07 2015

ME
15-10-07

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Wednesday, September 16, 2015 3:35:25 PM

Page 1

136898

D3230-041

Start Date: 9/17/15

Required Date: 10/02/15

Start Qty: -1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC
15.04.14 revD as per dwg DD verified by:JLM IPP Rev:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3		Manufactured	No			110	Each	26.0000	2	2		DAS 43 9-89	SEP 23 2015
D2232-3													
Basket Hinge													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				26					
					115847			20					
					132731			6					
D2327-3		Manufactured	No			110	Each	9.0000	2	2		DAS 43 9-89	SEP 23 2015
D2327-3													
Spacer Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				9					
					131972			9					
D3759-1		Manufactured	No			110	Each	24.0000	5	5		DAS 43 9-89	SEP 23 2015
D3759-1													
Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				24					
					135756			24					
D4021-9		Manufactured	No			110	Each	36.0000	4	4		DAS 43 9-89	SEP 23 2015
D4021-9													
Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				36					
					120334			2					
					122601			4					
					134919			30					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Wednesday, September 16, 2015 3:35:25 PM

Page 2

Work Order ID: 136898

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly

136898

D3230-041

Start Date: 9/17/15

Required Date: 10/02/15

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

110

sf

408.9522

5.15

5.421053

DAS

43

9-89

SEP 23 2015

✓ *M304FX0 75-16F*

Expanded Metal Flat SS

**

4132745 → 10 DC6

Location

Loc Qty

Loc Code

WA004

408.9522

M132745

208.8922

M132864

40.06

M132967

160

M304TS0.750W.065

Purchased

No

110

f

881.3500

26

27.36842

DAS

43

9-89

SEP 23 2015

✓ *M304TS0 750W 065*

304 SQ Tube .75x.75x.065W

**

4133165 → 30 feet
4132924

Location

Loc Qty

Loc Code

WA004

881.35

125513

14

m128495

95.35

m132190

30

m132270

142

m132924

600

Wednesday, September 16, 2015 3:35:25 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER : ☐																																																																					

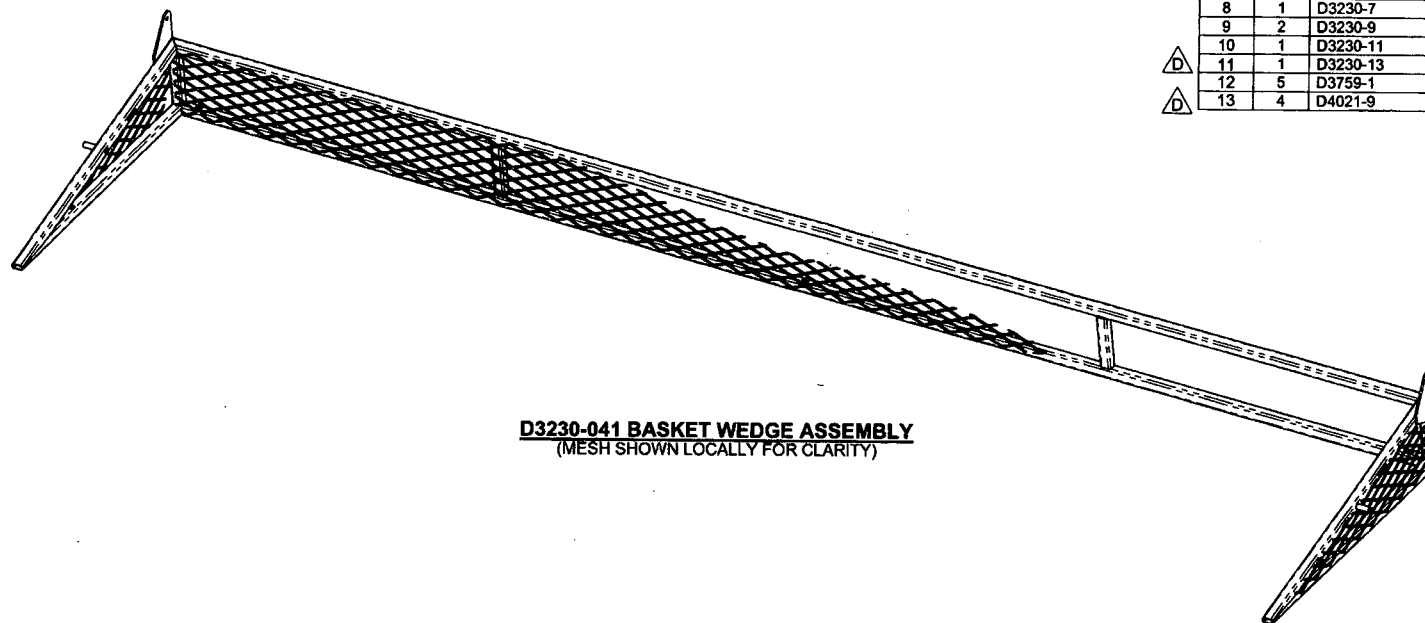
8 7 6 5 4 3 2 1

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D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3230-041	BASKET WEDGE ASSEMBLY
1	2	D2232-3	HINGE PLATE
2	2	D2327-3	SPACER BUSHING
3	1	D3230-1	RIB
4	1	D3230-2	RIB
5	1	D3230-3	RIB
6	1	D3230-4	RIB
7	4	D3230-5	RIB
8	1	D3230-7	RIB
9	2	D3230-9	SIDE MESH
10	1	D3230-11	FRONT MESH
11	1	D3230-13	RIB
12	5	D3759-1	BUSHING
13	4	D4021-9	BUSHING

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2015 APR 13
ECN 15-559 A.P.

20150916 SH 136898

D	CHANGE OVERALL LENGTH TO 95.75 (WAS 96.00) TO IMPROVE FIT ON BASKET (REF NCR15-4557); ADD DETAIL G (SH 2); ADD D3230-13, D4021-9 (4 PL)	DB	15.03.26
C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE

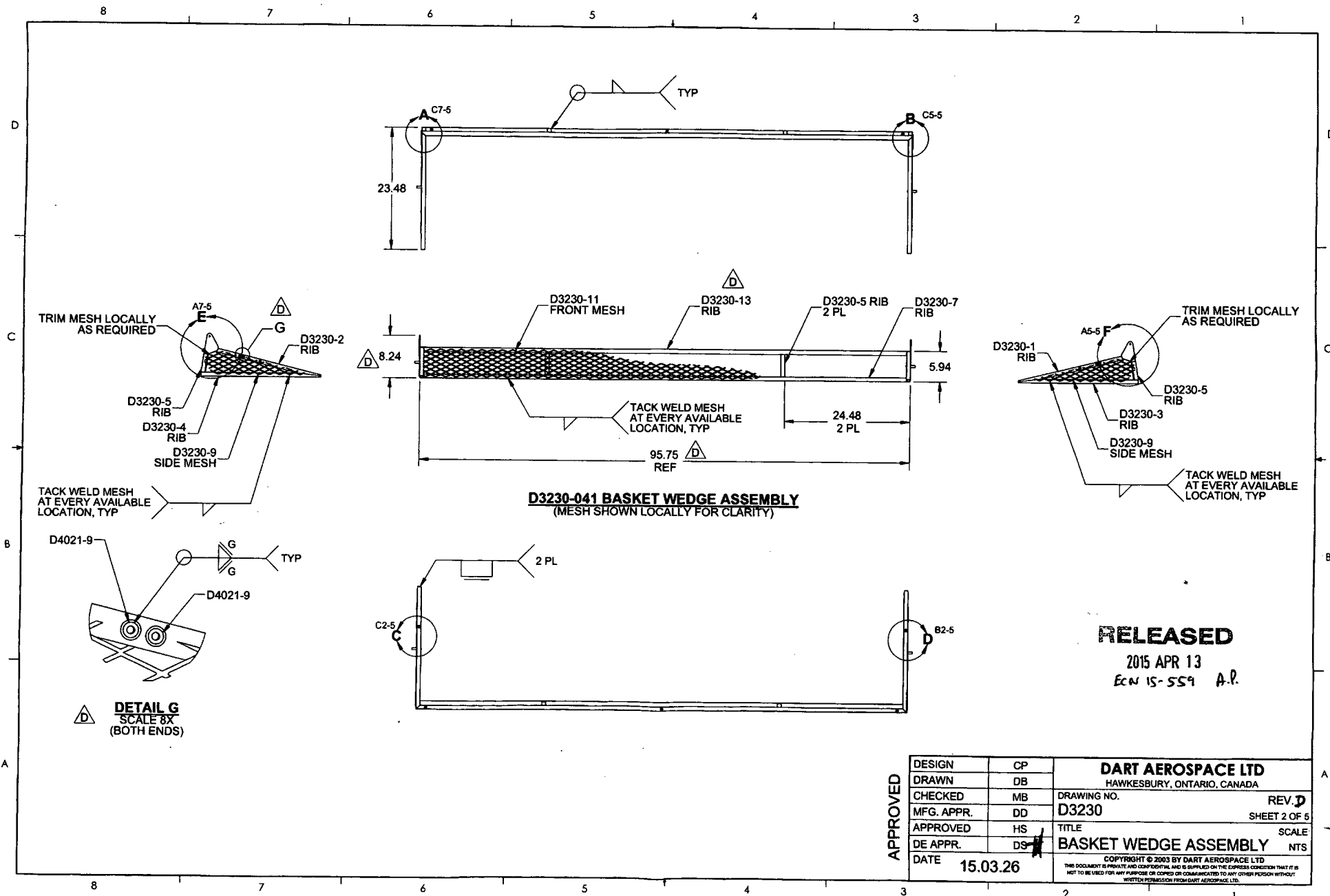
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DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
DATE	15.03.26	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 19.8 lbs
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1



APPROVED	DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	MB	DRAWING NO.	REV. D
	MFG. APPR.	DD	D3230	SHEET 2 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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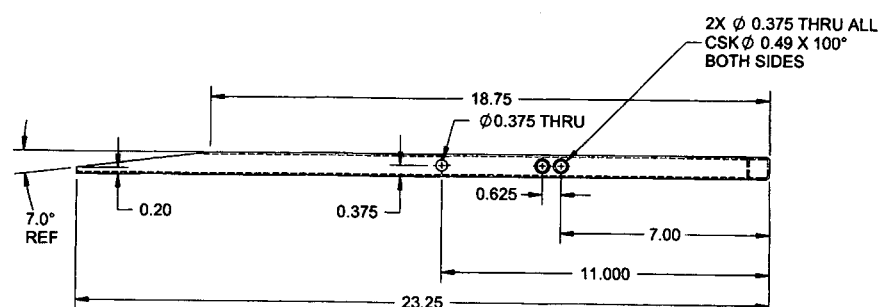
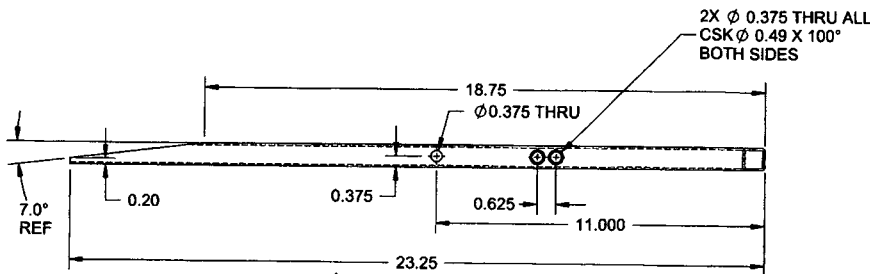
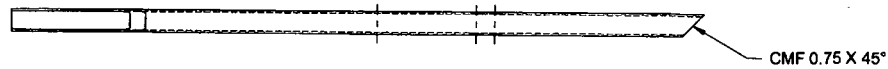
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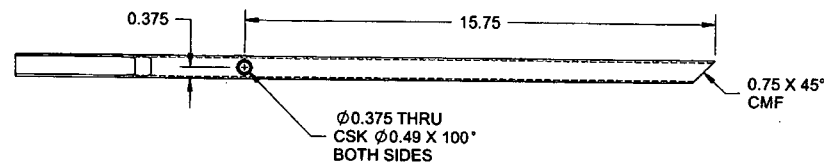
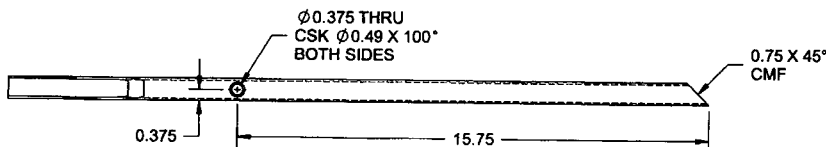
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D3230-1 RIB

D3230-2 RIB



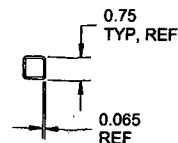
D3230-3 RIB

D3230-4 RIB

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ECN 15-559 A.P.

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH

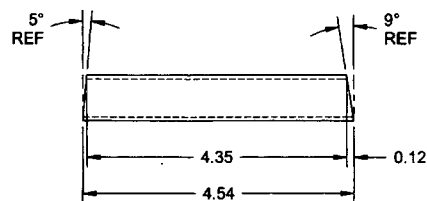


TYPICAL SECTION VIEW

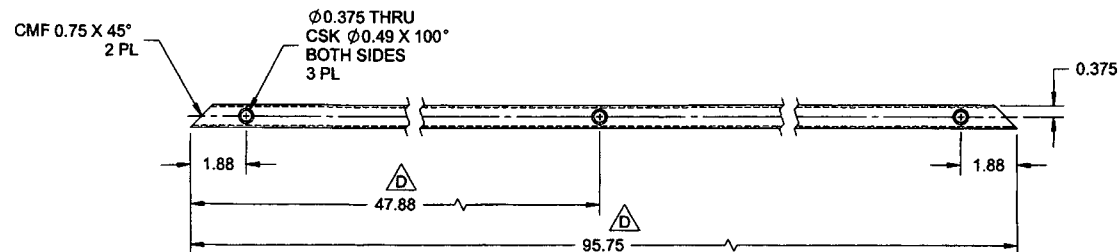
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DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
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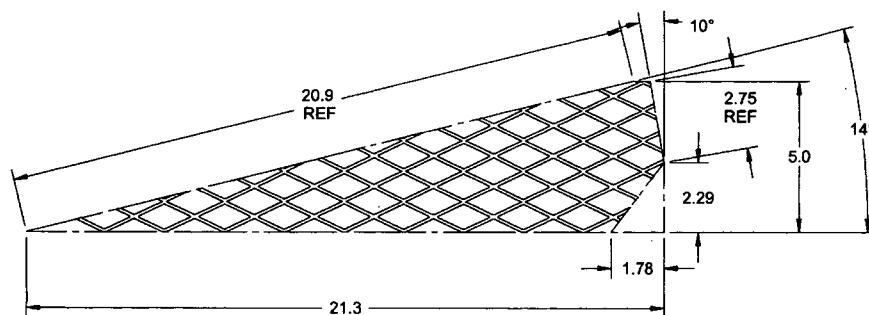
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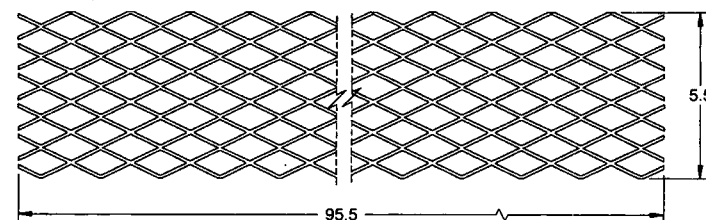
D3230-5 RIB



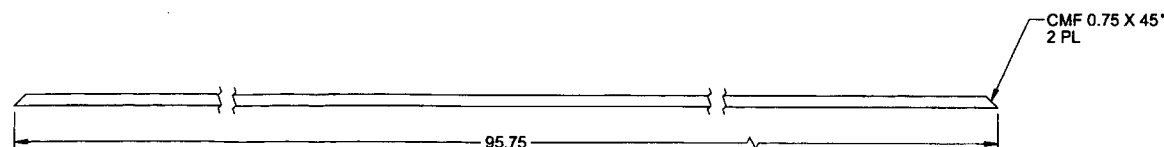
D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH



D3230-13 RIB

NOTES:

1) MATERIAL:

D3230-5/-7/-13: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs

D3230-9 = 0.20 lbs; D3230-11 = 1.94 lbs; D3230-13 = 4.56 lbs

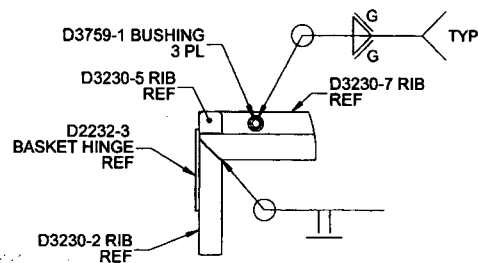
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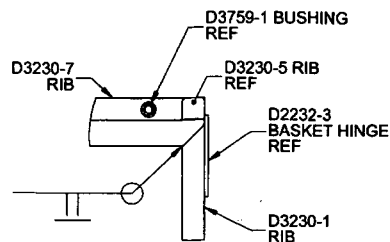
ECN 15-559 A.R.

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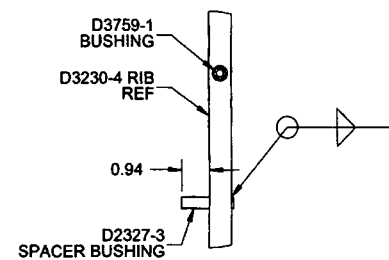
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
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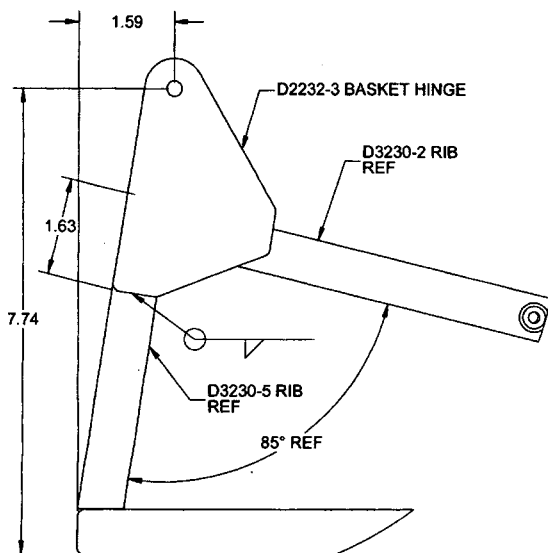
DETAIL A D6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



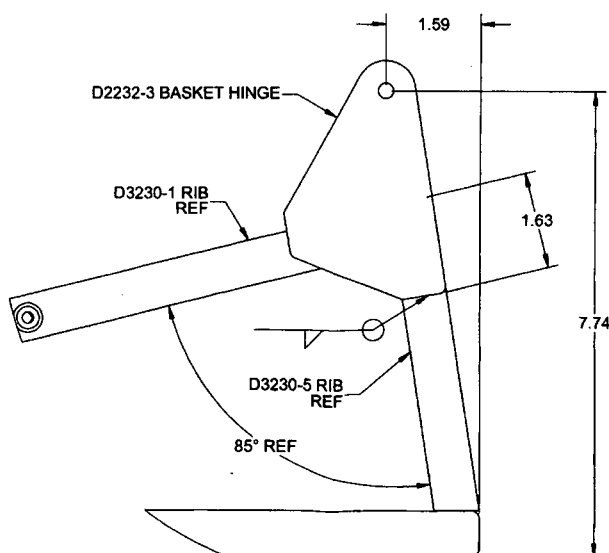
DETAIL B D3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



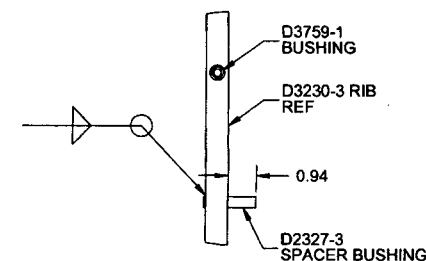
DETAIL C B3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



DETAIL E C7-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL F C2-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL D B3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X

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CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
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